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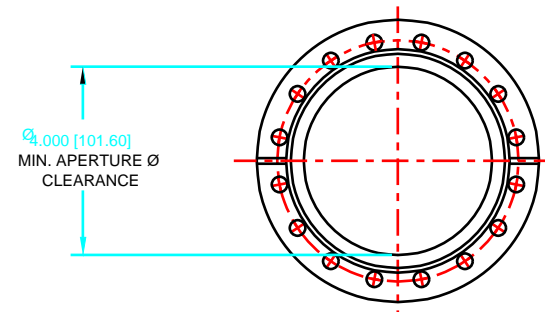
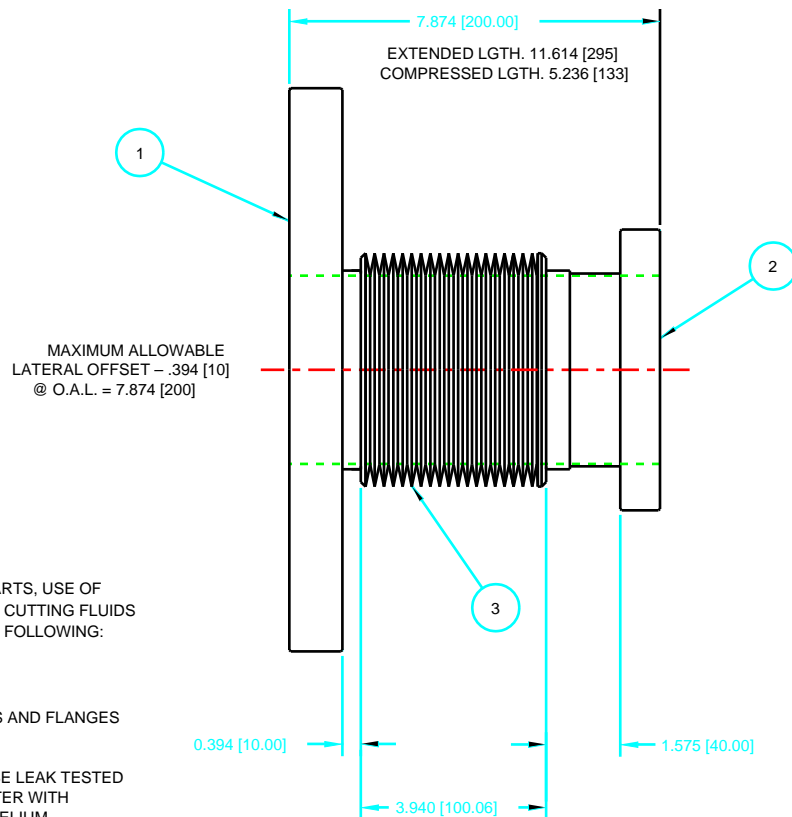
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NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS

ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

- 2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096
- 2 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651
- 1 NOR-CAL PRODUCTS, INC.
1967 S. OREGON ST.
P.O. BOX 518
YREKA, CA. 96097



3		ST'D. BELLOWS CAT. #497 - 400 - 6 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100030	8" CF. ROTATABLE FLANGE		1
1	N.C. #1200-000N	12" CF. NONROTATABLE FLANGE 4" I.D.		1

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF	
TOLERANCES		ARGONNE NATIONAL LABORATORY	
DECIMALS	ANGLES	A14776	

± .03 [7620]	± .25 °	DRAWN BY	DATE	CHEF DESIGN ENGINEER	DATE	TITLE
± .01 [0.25]		MUSCIA	2/17/93			ADVANCED PHOTON SOURCE
± .005 [0.127]		CHECKED BY		OP LEADER		V2 - 85 WELDED BELLOWS ASSY.

SURFACE ROUGHNESS	125	DESIGNER	PROJECT MOR	APPROVED/RELEASED		12" - 8" CF. 4" I.D. X 200mm
MUSCIA						

REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ.	DESIGNER	PROJECT MOR	APPROVED/RELEASED			
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST. 044	MUSCIA					
FINISHING & POLISHING TO BE IN ACCORDANCE WITH LATEST ASST. 044	RESPONSIBLE ENGINEER					

DO NOT SCALE DRAWING	MATERIAL	SCALE	SIZE	DRAWING NUMBER
	SEE PARTS LIST	HALF	C	4105090702-880000-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE	SHEET	1 of 1
	REVISIONS					

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